

slp 19/04

Work Order ID 68044



Page 1

Tuesday, April 05, 2011 3:13:18 PM

Item ID: D4273-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly, RH

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 4/04/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4273	D
D4279	B

100 Weld per dwg A/R S.S. rod Batch: 115728 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-
N ON PAGE 7, DWG D4273, NEED TO WELDED AFTHET MESH IS
INSTALL) weld as per dwg D4273 using DT9610A

visual inspect before welding mesh

2- Cut D4279-1 base mesh and all tack weld mesh on basket as per dwg D4273
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D3913

take lid to locate hinge and bracket

110



QC

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

Quality Control

BF
11-04-14

11-04-14

1 *0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 68044

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Page 2

Item ID: D4273-042

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Setup Start



Revision ID:

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Item Name: Basket Base Assembly, RH

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

ml 11 04 14 (1)

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 PR 11-4-14.

W/O:		WORK ORDER CHANGES					
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Item ID:	D4273-042	Accept		Setup	Start	
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Start Date:	4/5/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/8/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Powdercoat								
	Powder Coating								
	Memo	0.00							
	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT:								
	START TIME: 3:45								
	OVEN TEMPERATURE: 400°								
	FINISH TIME: 4:15								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								
140 	QC3- Inspect Part Finish	0.00							
	QC								
	Quality Control								
	Memo	0.00							

1 BL 11-4-14.

954/04/120

W/O:		WORK ORDER CHANGES					
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Page 4

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Identify as per dwg & Stock Location: *G-A*

0.00

Memo

W/O 68040

0.00

Packaging

E. Sa / 04 / 19 @

160



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*11/4/19**MF*
11-04-19

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

Tuesday, April 05, 2011 3:13:23 PM

Work Order ID: 68044

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH



Start Date: 4/5/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.16 new issue DD verf:EC
 11.01.20 AS PER DWG REV.C DD verf:EC
 AS PER DWG REV.D DD verf:EC
 IPP Rev:B
 IPP Rev:C 11.03.03

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			100	sf	530.0526	26.195	26.195			
<div> <div> </div> <div> <p><i>D4279-1</i></p> <p><i>MF 11-09-13</i></p> <p><i>68137</i></p> </div> </div>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA	530.0526						
						115012	150						
						117197	380.0526						
* D3913-1 Rib		Manufactured	No			100	Each	2.0000	1				
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA006	2						
						66629	2						
✓ D3913-3 Rib		Manufactured	No			100	Each	4.0000	1				
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA006	4						
						65314	1						
						67475	3						

Pl 11.04.13

26.195
Pl 11.04.08

1
Pl 11.04.08

1

W/O:		WORK ORDER CHANGES					
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Work Order ID: 68044

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 4/5/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-9 Manufactured No 100 Each 4.0000

Hinge Rib



1

1

Pl 11.04.08

Location

Loc Qty

Loc Code

WA006

4

66630

2

67126

2

①

D3916-5 Manufactured No 100 Each 5.0000

Light Rib



3

3

Pl 11.04.08

Location

Loc Qty

Loc Code

WA

5

66696

5

B67979 → ③

D4017-7 Manufactured No 100 Each 3.0000

Rib



1

1

B66885 → ① Pl 11.04.08

Location

Loc Qty

Loc Code

WA005

3

66885

3

D4277-3 Manufactured No 100 Each 0.0000

Rib



1

1

B68052 → ① Pl 11.04.08

D4277-5 Manufactured No 100 Each 0.0000

Rib



2

2

B68054 → ② Pl 11.04.08

D4277-9 Manufactured No 100 Each 0.0000

Rib



1

1

B68045 → ① Pl 11.04.08

W/O:		WORK ORDER CHANGES					
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Work Order ID: 68044

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH



Start Date: 4/5/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4277-19 Manufactured No

100 Each

0.0000

1 1



Rib

B65683 → ① Pl 11.04.08

D4278-041 Manufactured No

100 Each

1.0000

1 1



Upper Rib Assembly-Hoop

Pl 11.04.08

Location

Loc Qty

Loc Code

WA005

1

65685

1

①

D4278-045 Manufactured No

100 Each

0.0000

2 2



Rib Assembly, Fwd Cham

B68047 → ② Pl 11.04.08

D4278-047 Manufactured No

100 Each

0.0000

1 1



Upper Rib Assembly-Straight

B68049 → ① Pl 11.04.08

D4306-1 Manufactured No

100 Each

0.0000

1 1



Rib

B68046 → ① Pl 11.04.08

D4306-044 Manufactured No

100 Each

0.0000

1 1



Rib Assembly, RH

B68053 → ① Pl 11.04.08

D4306-045 Manufactured No

100 Each

0.0000

1 1



Rib Assembly

B68050 → ① Pl 11.04.08

W/O:		WORK ORDER CHANGES					
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Work Order ID: 68044

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 4/5/2011

Required Date: 4/8/2011


Start Qty: 1.00

Required Qty: 1.00

✓ D2581 Manufactured No

 Mounting Bracket

100 Each 32.0000

 2 2
 Pl 11.04.08


Location	Loc Qty	Loc Code
WA005	32	
66500	10	
66806	22	

②

✓ D3913-15 Manufactured No

 Wide Handle Plate

100 Each 5.0000

 1 1
 Pl 11.04.08


Location	Loc Qty	Loc Code
WA	3	
67751	3	
WA005	2	
66695	2	

①

✓ D4016-1 Manufactured No

 Hinge Half, Base

100 Each 31.0000

 3 3
 Pl 11.04.08

Location	Loc Qty	Loc Code
WA	18	
66418	0	
67473	18	
WA005	13	
66418	13	

③

W/O:		WORK ORDER CHANGES					
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Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 4/5/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4021-1
Handle Plate

Manufactured No 100 Each 21.0000

3 3
PL11.04.08

Location	Loc Qty	Loc Code
WA	13	
67474	13	
WA005	8	
66697	8	

✓ D4279-3
Mesh, Chamfer

Manufactured No 100 Each 1.0000

1 1
PL11.04.13

Location	Loc Qty	Loc Code
WA	1	
65694	1	

✓ D4279-5
End Mesh, Basket

Manufactured No 100 Each 0.0000

1 1
B68051 → ① PL11.04.13

✓ D4279-7
End Mesh, Basket

Manufactured No 100 Each 0.0000

2 2
B68056 → ② PL11.04.13

✓ D4279-9
End Mesh, Basket

Manufactured No 100 Each 1.0000

1 1
PL11.04.13

Location	Loc Qty	Loc Code
WA	1	
63790	1	

✓ D4279-11
Mesh, Base

Manufactured No 100 Each 0.0000

1 1
B68058 → ① PL11.04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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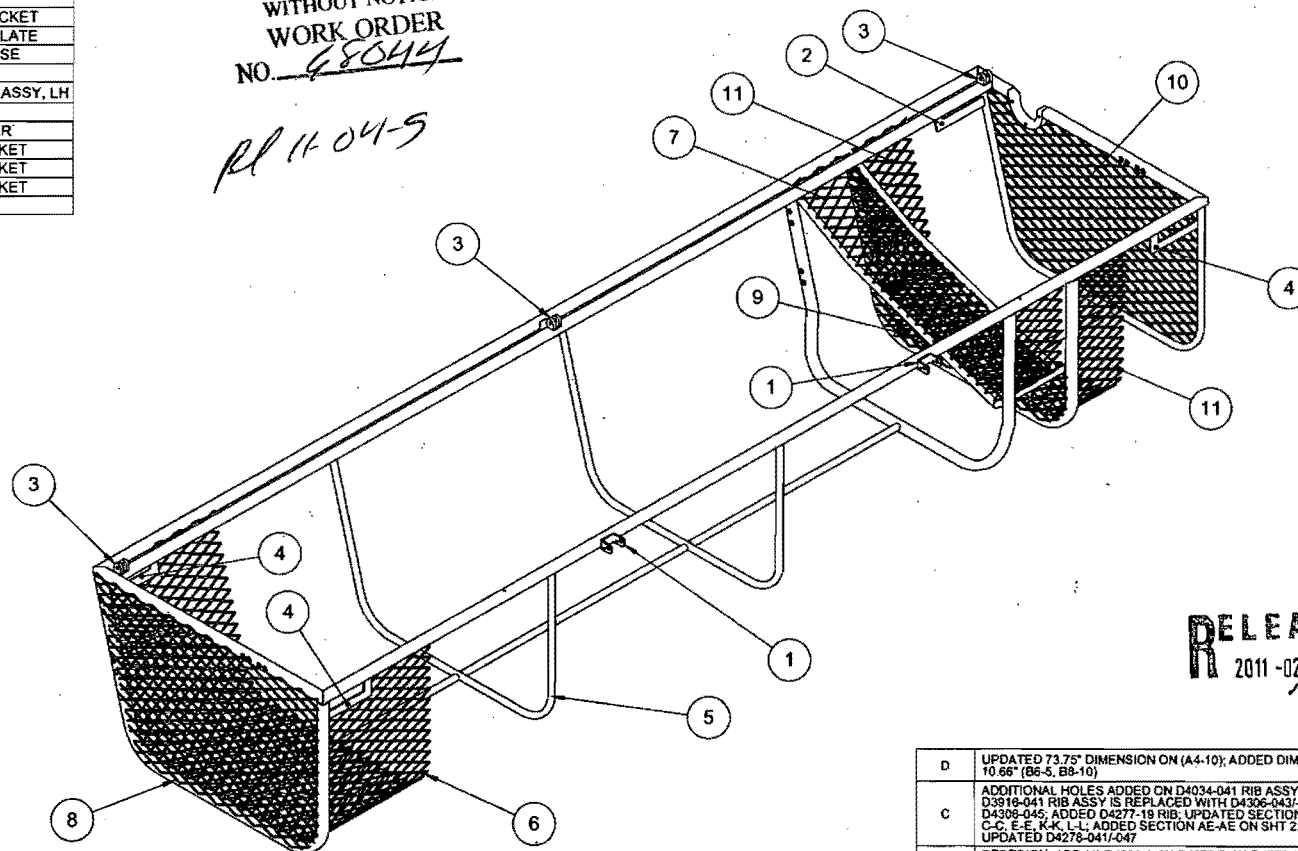
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68044

RL 11-04-5

ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4273-041	BASKET BASE ASSY, LH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-141	BASKET FRAME ASSY, LH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE



D4273-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

RELEASED
R 2011-02-24
WD

D	UPDATED 73.75" DIMENSION ON (A4-10); ADDED DIM 10.66" (B6-5, B8-10)	SC	11.02.09
C	ADDITIONAL HOLES ADDED ON D4034-041 RIB ASSY: D3916-041 RIB ASSY IS REPLACED WITH D4306-043/044 & D4306-045; ADDED D4277-19 RIB; UPDATED SECTION B-B, C-C, E-E, K-K, L-L; ADDED SECTION AE-AE ON SHT 2; UPDATED D4278-041/047	SC	10.12.23
B	REDESIGN: ADD (1) D4021-1, (1) D4279-7, (1) D4279-11 (D6-1, D6-8); RMV D4277-17, D4278-043 (SHT 4.9); ADD (1) D3918-1, (2) D4277-5, (1) D4277-9, (1) D4306-1 (D6-4, D6-9), RMV (1) D4277-3 (D6-4, D6-9); 24.25 WAS 20.25 (A5-5, A5-10)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4273** REV. D
SHEET 1 OF 10

TITLE **BASKET BASE ASSY** SCALE NTS

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DETAIL D (D7-2)
D4279-1 MESH - BASE
TACK WELD MESH AT EVERY AVAIL LOCATION

SECTION AE-AE (C7-2)
3 PLACES
D4279-1 MESH REF 10
D4021-1 HANDLE PLATE OR D3913-15 WIDE HANDLE PLATE REF
TACK WELD MESH AT EVERY AVAIL LOCATION

SECTION E-E (D6-2)
1 PLACE
D4279-1 MESH REF 10
D4021-1 HANDLE PLATE REF
TACK WELD MESH AT EVERY AVAIL LOCATION





D4273-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2011-02-34

DESIGN		JPH	
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.09		

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	D4273
TITLE	BASKET BASE ASSY
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REV. D
SHEET 2 OF 10
SCALE
NTS

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 2 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

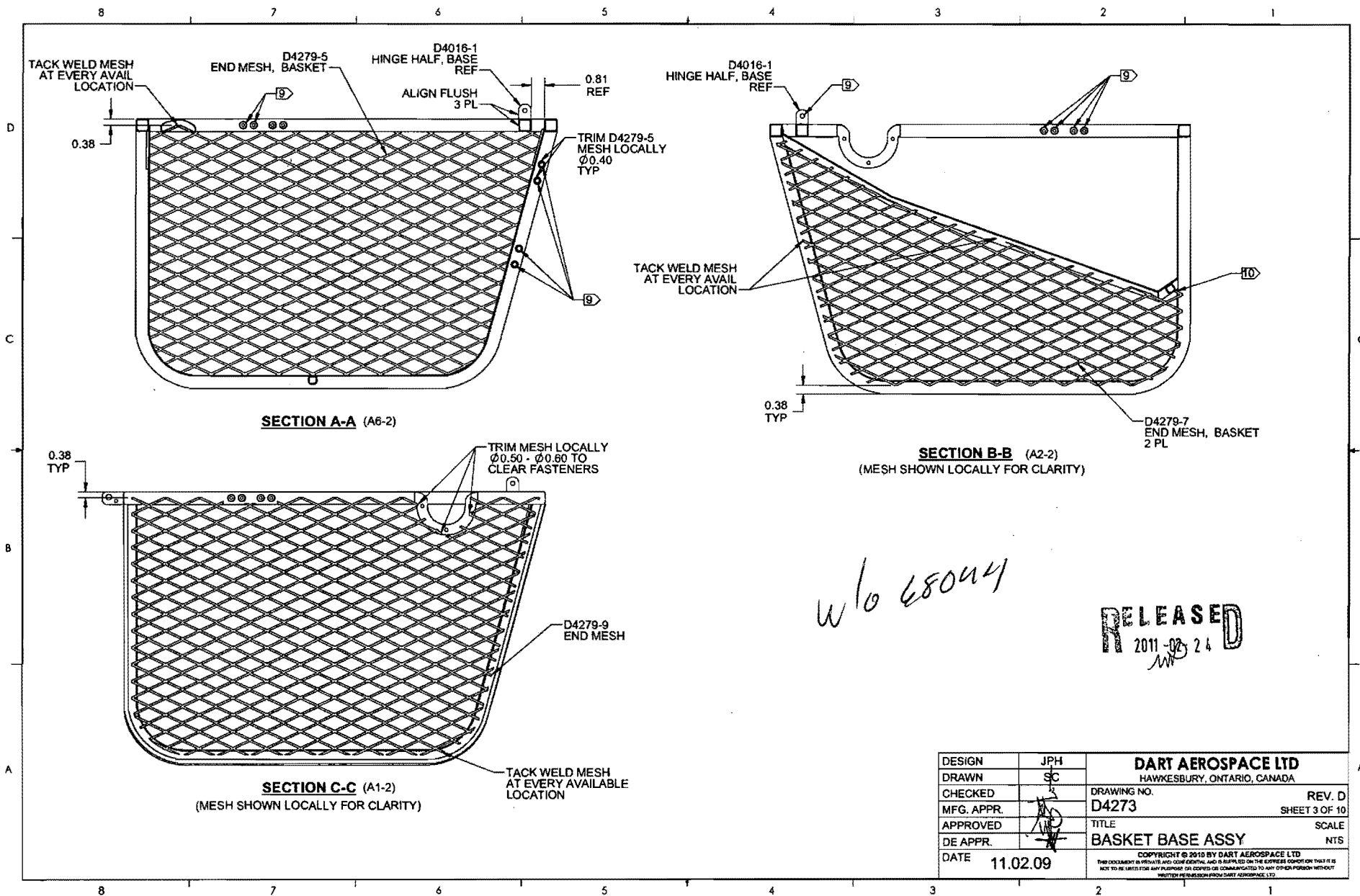
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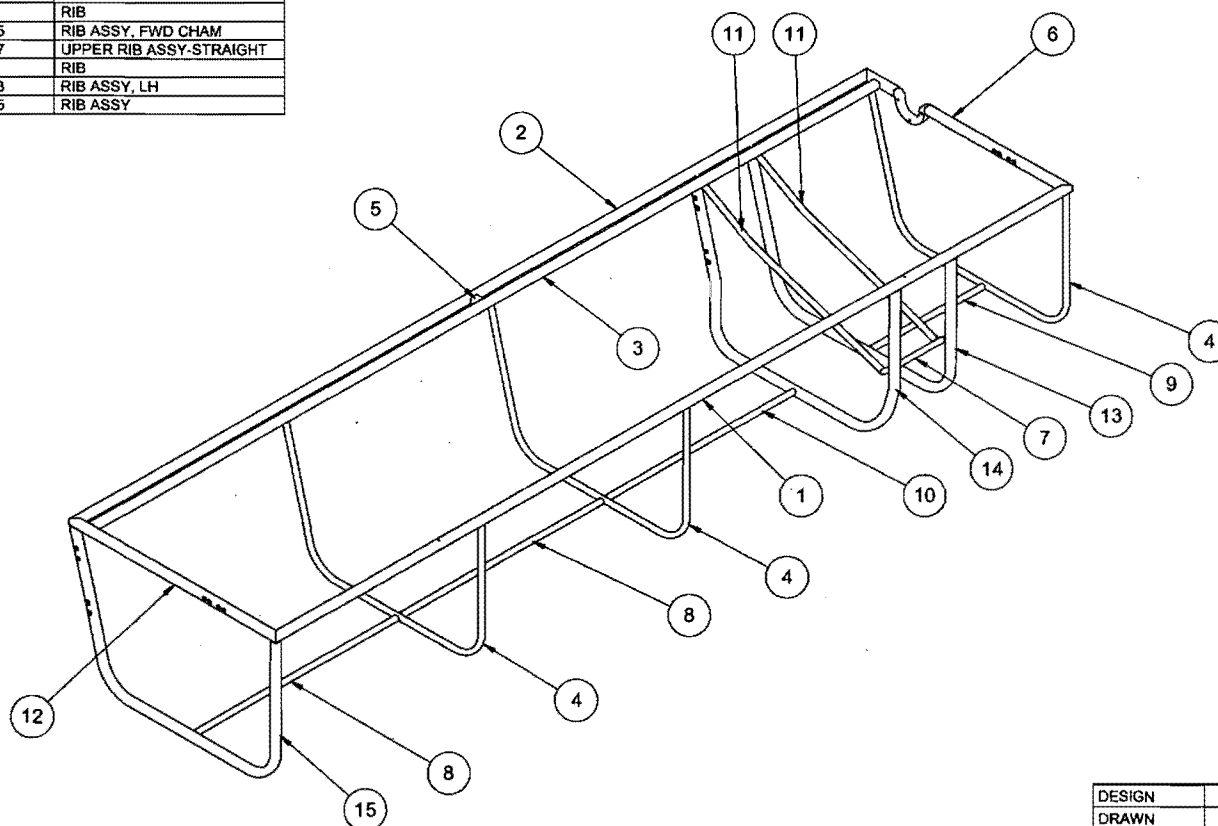
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-141	BASKET FRAME ASSY, LH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4034-041	AFT UPPER RIB ASSY
7	1	D4277-3	RIB
8	2	D4277-5	RIB
9	1	D4277-9	RIB
10	1	D4277-19	RIB
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-043	RIB ASSY, LH
15	1	D4306-045	RIB ASSY



D4273-141 FRAME ASSY, LH

u/o 68044

RELEASED
2011-02-21
WJ

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 4 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

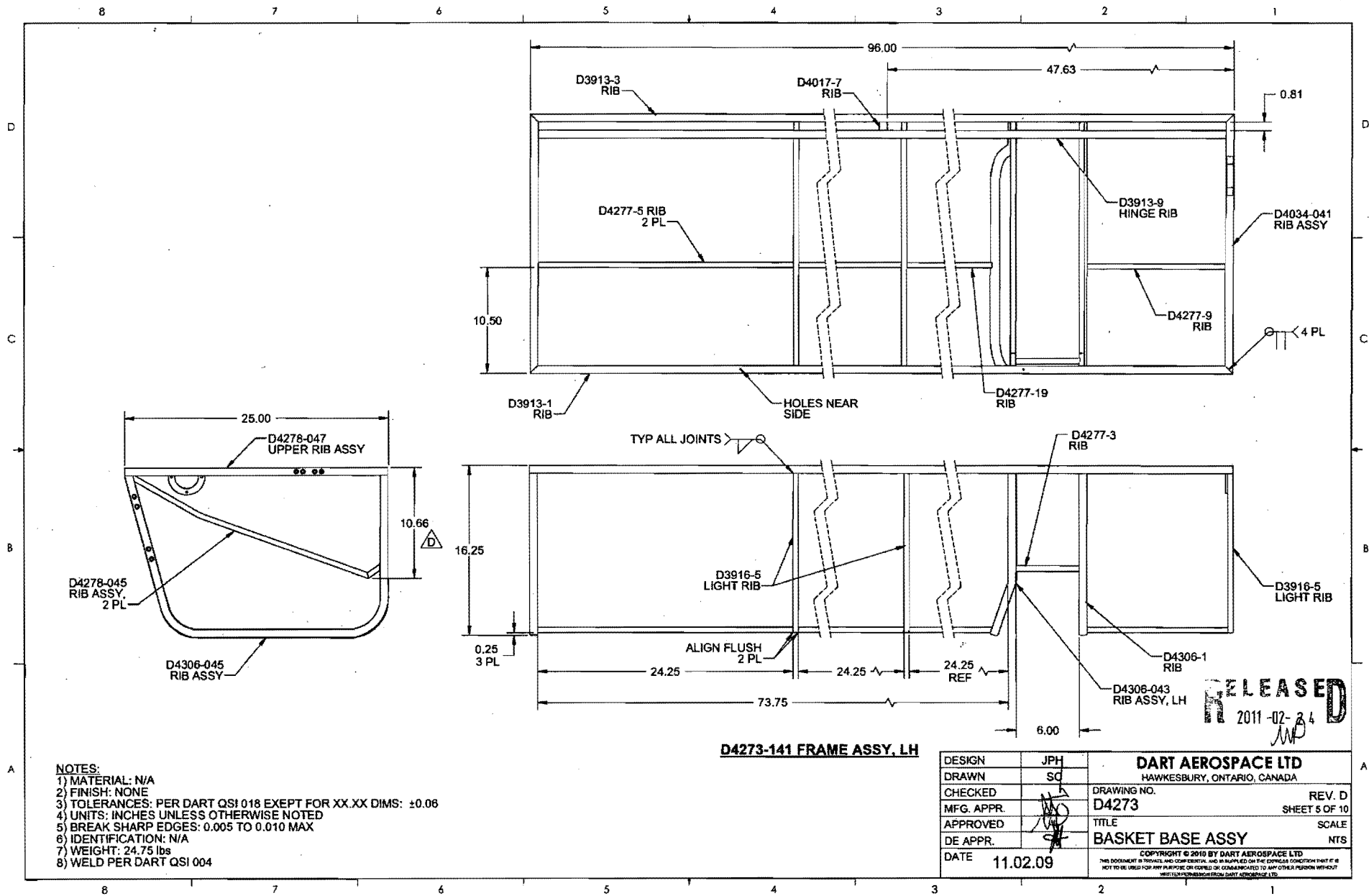
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

u1068094



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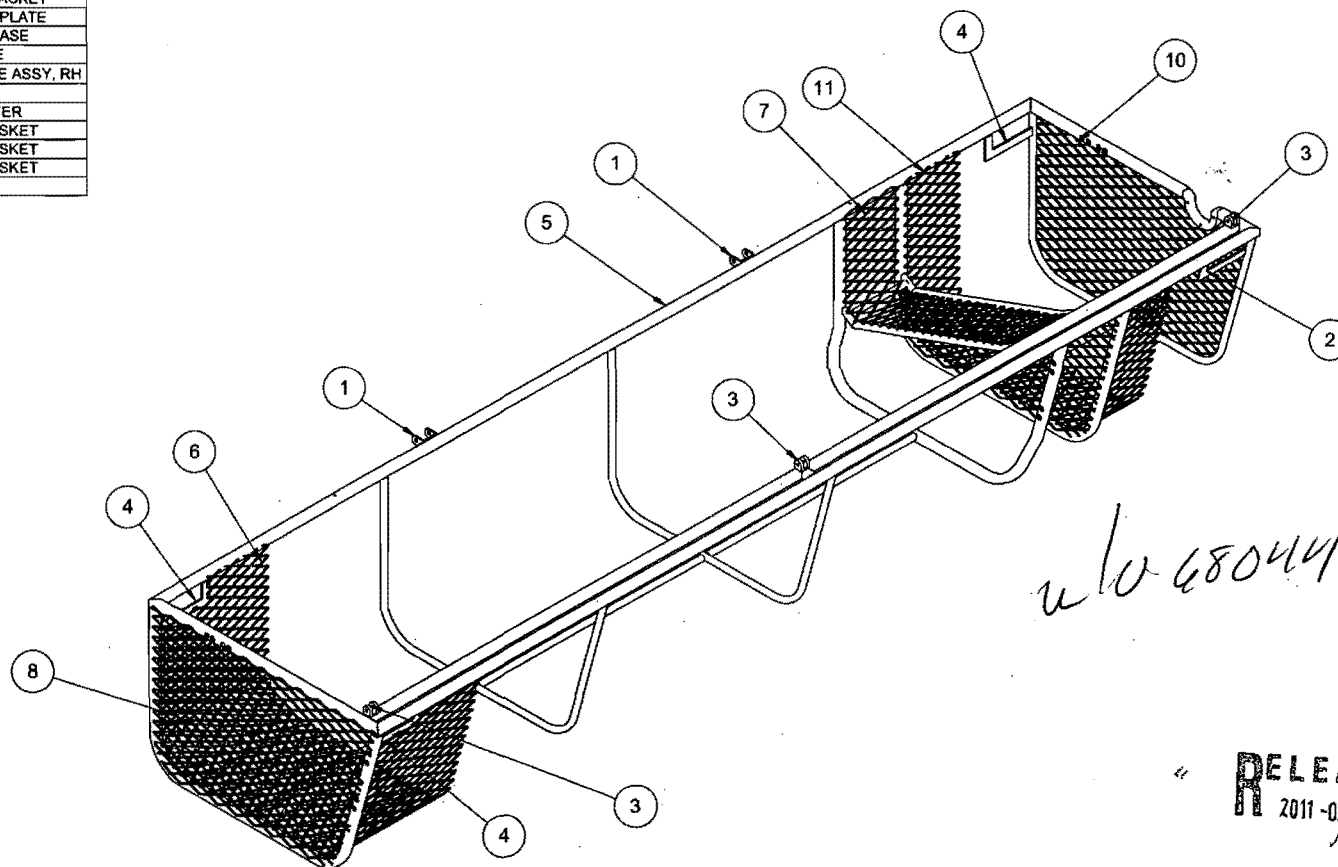
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ITEM	QTY -042	PART NUMBER	DESCRIPTION
	X	D4273-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-142	BASKET FRAME ASSY, RH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE



D4273-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

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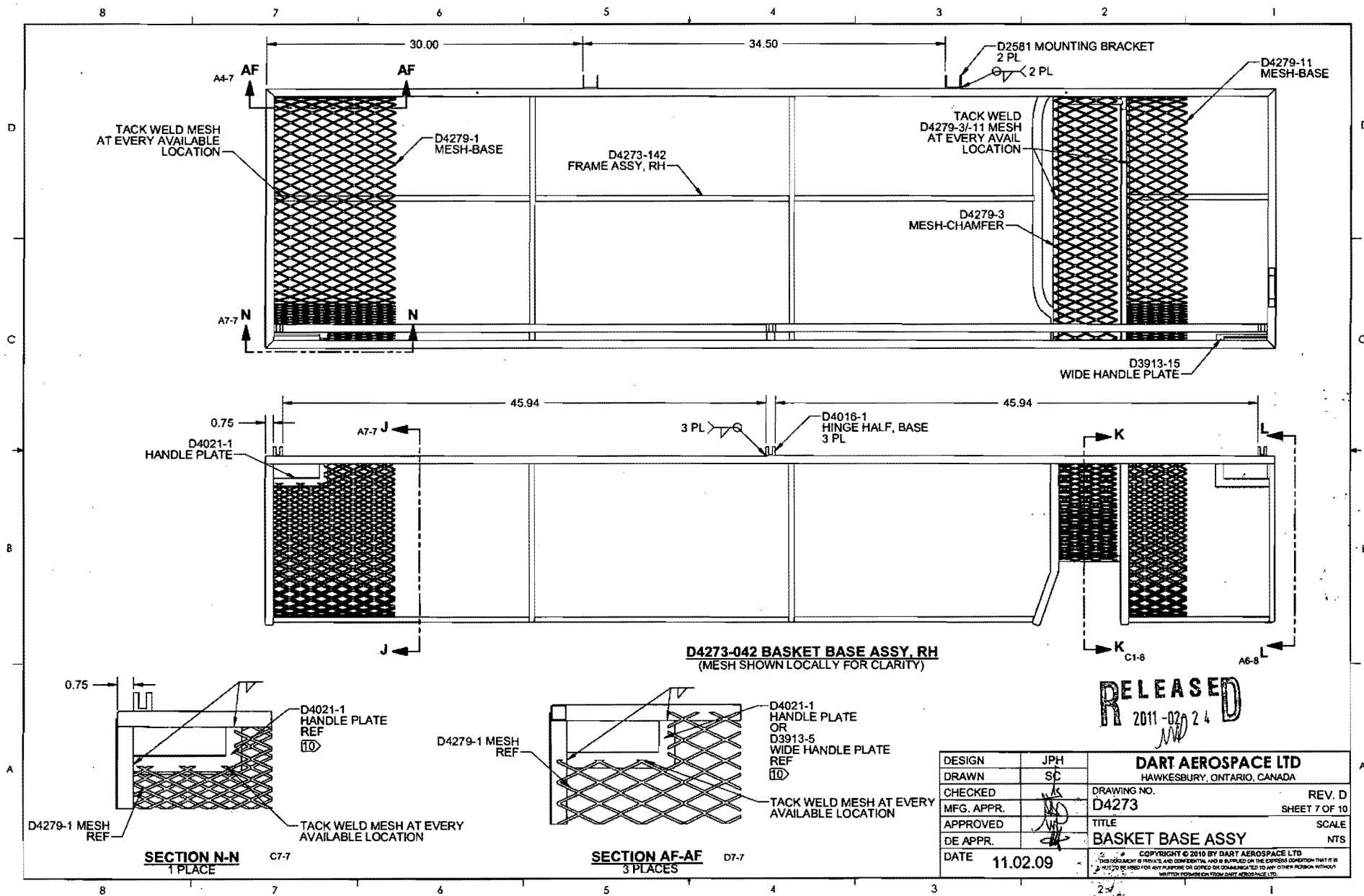
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WLO 68044



RELEASED
2011-02-24

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MFG. APPR.	AS	D4273	SHEET 7 OF 10
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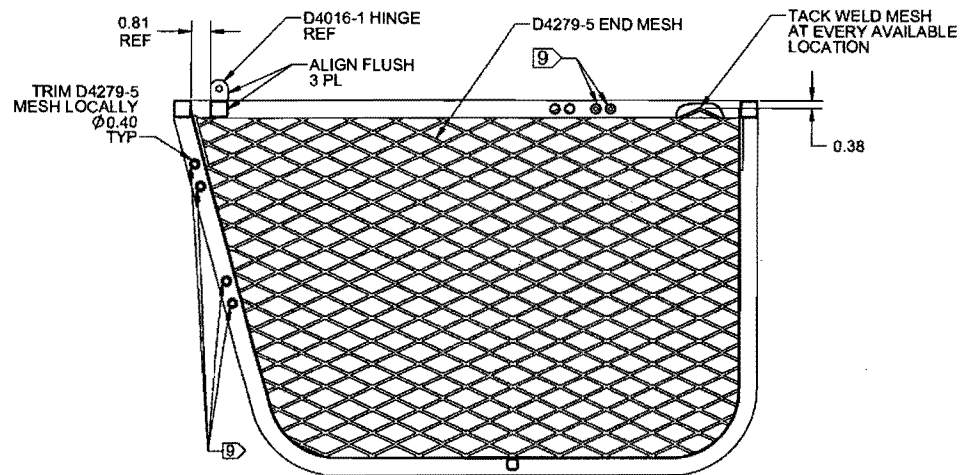
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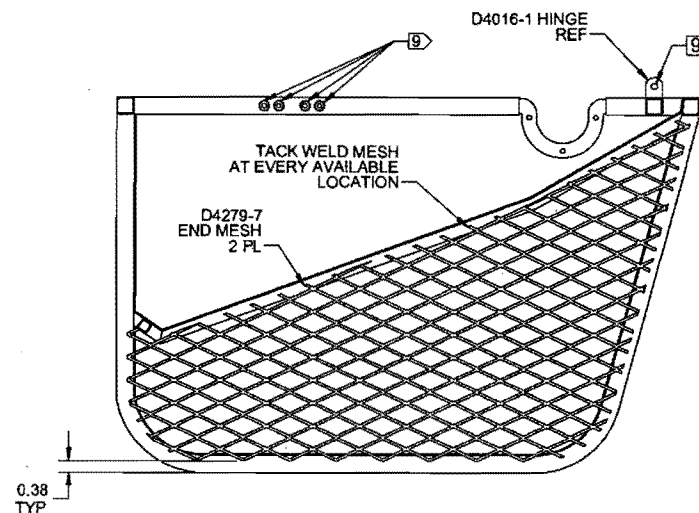
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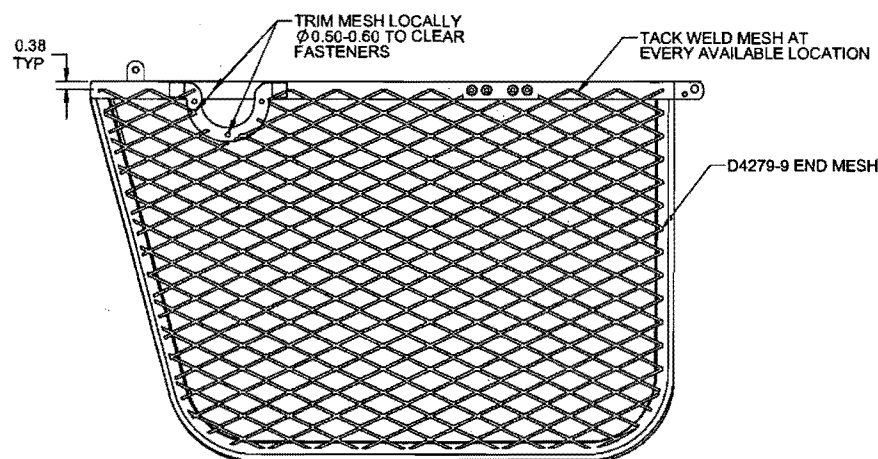
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SECTION J-J C6-7



SECTION K-K B2-7
(MESH SHOWN LOCALLY FOR CLARITY)



SECTION L-L B1-7
(MESH SHOWN LOCALLY FOR CLARITY)

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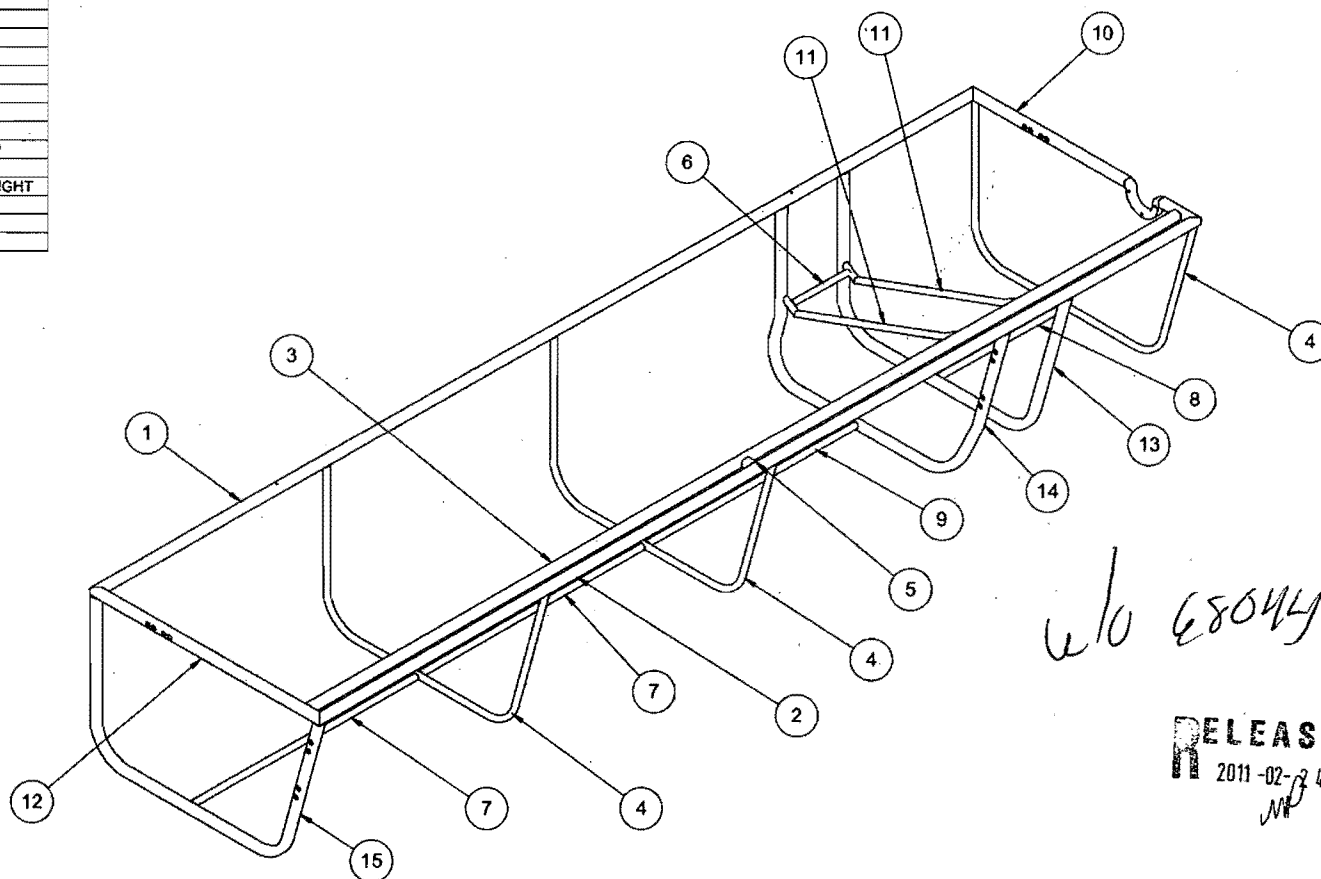
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-142	BASKET FRAME ASSY, RH
1	1	D3913-1	RIB
2	1	D3913-3*	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4277-3	RIB
7	2	D4277-5	RIB
8	1	D4277-9	RIB
9	1	D4277-19	RIB
10	1	D4278-041	UPPER RIB ASSY-HOOP
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-044	RIB ASSY, RH
15	1	D4306-045	RIB ASSY



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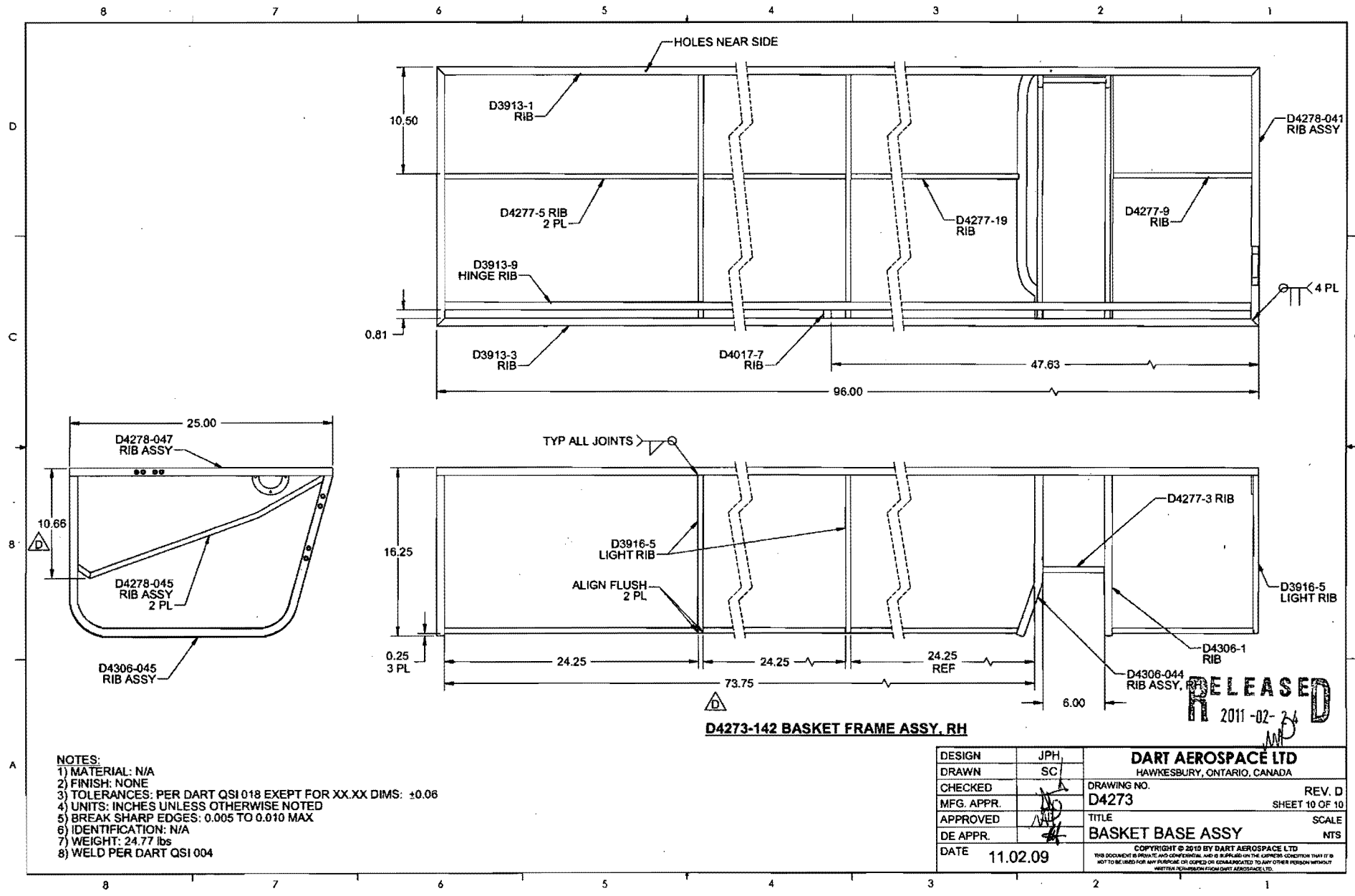
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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 EXCEPT FOR XX.XX DIMS: ± 0.06
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 24.77 lbs
 - 8) WELD PER DART QSI 004

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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